

Date: Friday, 31/10/2008 10:20:09 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206 A/B HIGH GEAR WEB
<b>Job Number</b> : 43120	
<b>Estimate Number</b> : 10455	
<b>P.O. Number</b> :	<b>Part Number</b> : D26543
<b>This Issue</b> : 31/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2654 REV E1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : E1
<b>Previous Run</b> : 42771	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 07/11/2008 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 08.10.31</u>	
<b>Comment</b> : Est Rev:D 99.02.04 Fixed typo, Changed procedureDM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I-Beam' thin
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-5	Web	B-38589 AWM 8-11-05

4 PCS \*

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

- 1-Cut D2600-5 to length as per Dwg D2654
- 2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654
- 3-Using the uni-bit, open holes to finish size as per Dwg D2654
- 4-Deburr holes and ends

AWM 8-11-05

4A

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

8-11-5

4

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 8-11-05

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 31/10/2008 10:20:09 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 43120

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

④

u 8-11-5

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: L6

④

u

8-11-5

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/07

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector






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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

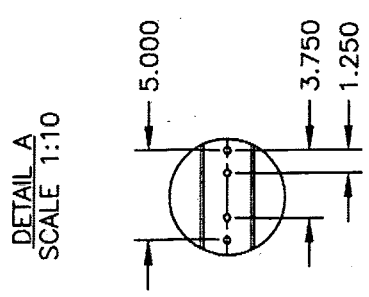
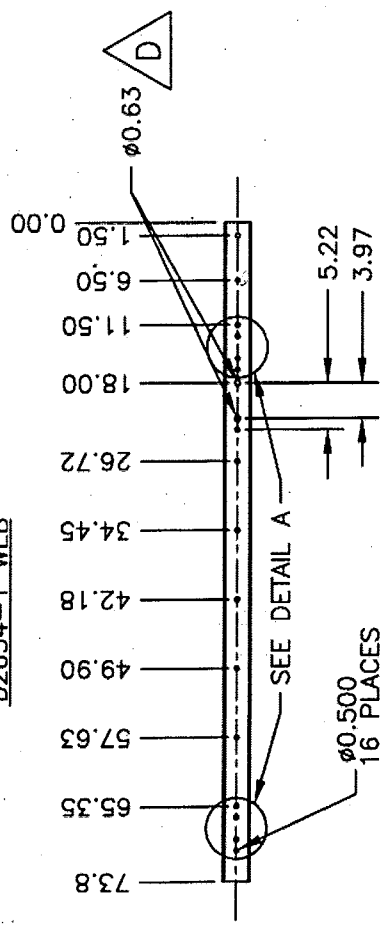
**NOTE:** Date & initial all entries



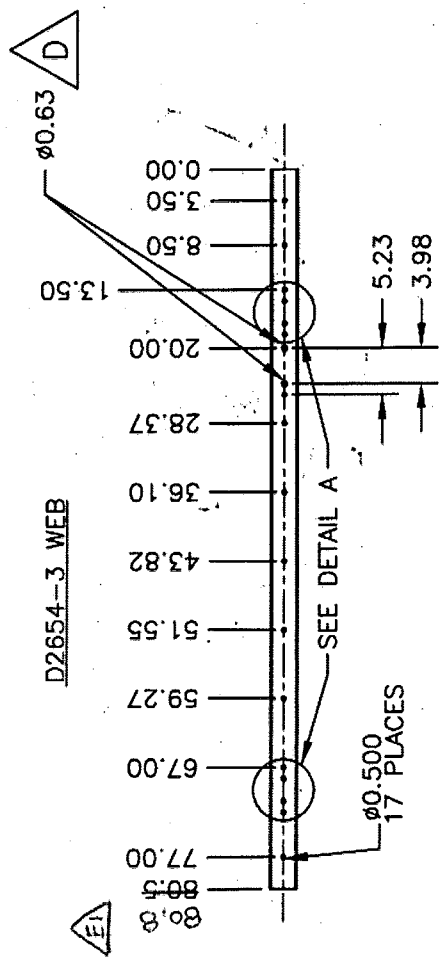
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CHECKED 		APPROVED 		DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26				TITLE WEB	SCALE 1:20
A	97.03.25		NEW ISSUE		
B	97.06.26		ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29		CHANGED HOLE PATTERN		
D	98.01.15		GHW HOLES CHANGED TO $\phi 0.63$		
E	04.05.26		CHANGE LENGTHS, REFORMAT		
E1		04.08.04	PER TOOLING; 80.8 WAS 80.5		

RELEASED  
04.06.22

D2654-1 WEB



D2654-3 WEB

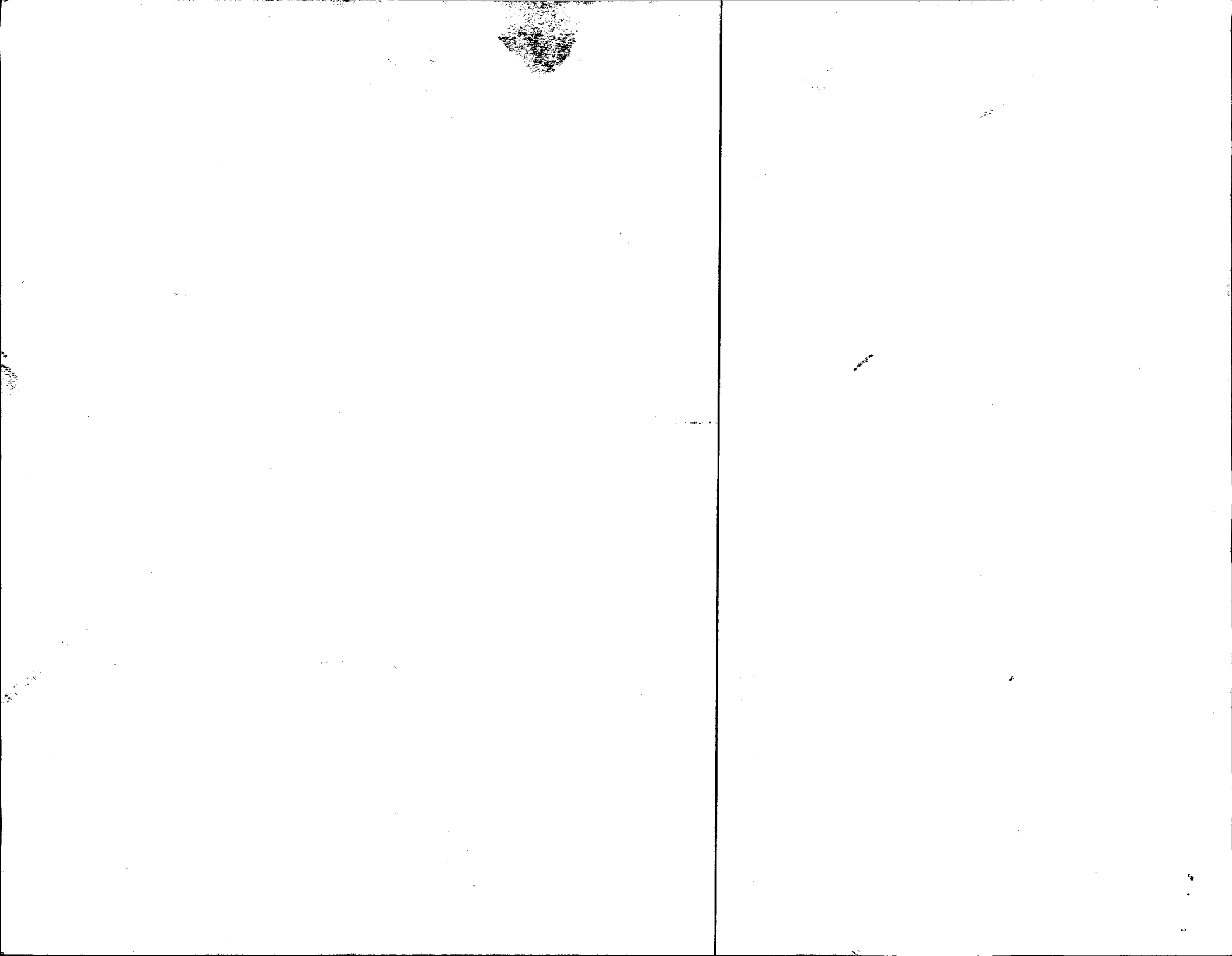


MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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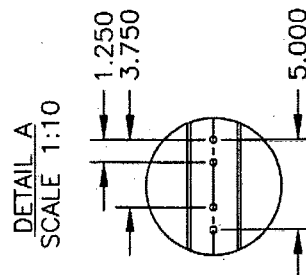
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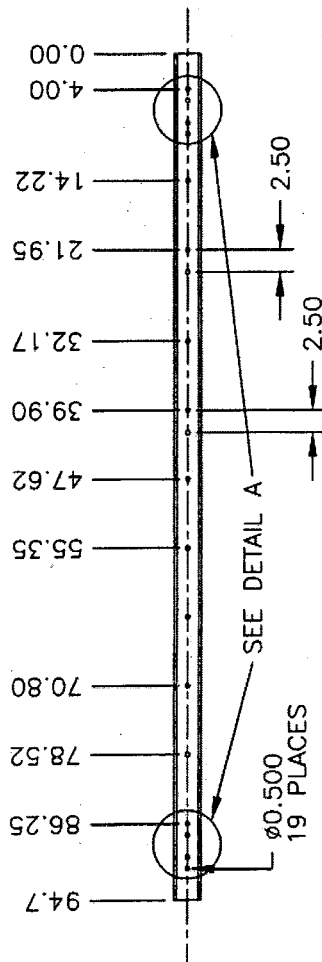


DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

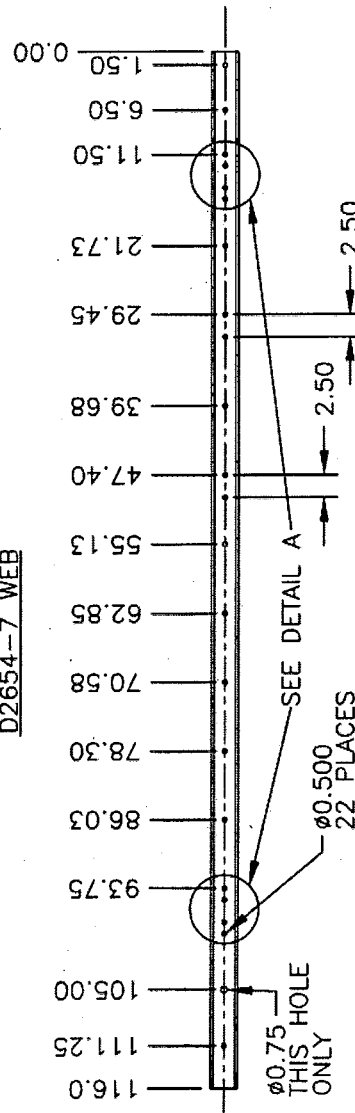
RELEASED  
04.06.22



D2654-5 WEB



D2654-7 WEB



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